



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-541
Job Sheet 196217



Part No: D206-642-541

Job Qty: 1 pcs

Part Name: Repl.Skld.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/10/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 7/19/19

Description: SIOP

Type: Stock

Note: DWG REV G IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC IPP Rev:F 08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09 revise details DD verified by:EC IPP Rev:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I 14.04.28 AS PER ECN14-520 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/19/19	7/19/19	0.00	2.17	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
114	QC 5	1 pcs	7/19/19	7/19/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
116	QC 10	1 pcs	7/19/19	7/19/19	0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		

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120 Handfinish - 1-1 Chemical-B4B	1 pcs	7/19/19	0.00 0.68	QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ JUL 03 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130 QC 7	1 pcs	7/19/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	BE
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	

					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 50	
150 Skidtubes - 2 - B4B	1 pcs	7/19/19	0.00 2.08	Skidtubes - 1 - B4B		DN
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		TF
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
160 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		BE
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
170 Skidtubes - 3 - B4B	1 pcs	7/19/19	0.00 2.17	Skidtubes - 1 - B4B		DN
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		#1 MGL
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
180 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		BE
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
190 Skidtubes - 4 - B4B	1 pcs	7/19/19	0.00 2.75	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		BB
				Skidtubes - 6 - B4B		

200 QC 5	1 pcs	7/19/19	0.00 0.00	Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
210 QC 10	1 pcs	7/19/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
220 Handfinish - 2-1 Pressure- B4B	1 pcs	7/19/19	0.00 0.45	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
230 Spray Paint - 2 - B4B	1 pcs	7/19/19	0.00 0.40	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
240 QC 14	1 pcs	7/19/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
244 Handfinish - 3-1- WingWalk- B4B	1 pcs	7/19/19	0.00 0.50	Handfinish - 3 - 1 - B4B	
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
246 QC 3	1 pcs	7/19/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	

				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	3 FEB 19-08-20
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
250 Handfinish - 4-1-Assembly-B4B	1 pcs	7/19/19	0.00 0.45	Handfinish - 4 - 1 - B4B	del 14-8-21
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
260 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS
				QC 5 - 43	19
				QC 5 - 49	9-00
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	7/19/19	0.00 0.68	Handfinish - 4 - 1 - B4B	del 14-8-21
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 -	

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				B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
280 QC 5	1	7/19/19	0.00 0.00	QC 5 - 10	
	pcs			QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
290 Packaging 3-1 - Stock - B4B	1	7/19/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs			Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

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40
9-89

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				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
295 DC - 1 - B4B	1	7/19/19	0.00 0.00	DC - 1 - B4B	AUG 27 2019
	pcs			DC - 2 - B4B	AUG 27 2019
300 QC 21 - FG	1	7/19/19	0.00 0.00	QC 21 - FG - 21	
	pcs			QC 21 - FG - 70	
				QC 21 - FG - 53	AUG 27 2019

Part Op 110 - (Skidtubes) ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- remove fwd indexing ridge as per Descriptions: dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: 138989/129811 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. 5- Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

114 - (QC5- Inspect part completeness to step on W/O)
 116 - (QC10- Inspect visual per QSI004- ground welds)
 120 - (Chemical Conversion Coat per QSI005 4.1)
 130 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Skidtubes) 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. (Adhere for 12 hours)
 160 - (QC5- Inspect part completeness to step on W/O)
 170 - (Skidtubes) 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Skidtubes) 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod 3-Grind cross bolt welds flush as per Dwg D3274. ****INSPECT FOR PIN HOLES IN WELD**** 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (QC10- Inspect visual per QSI004- ground welds)
 220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch
 230 - (Spray Paint / NDT Room) Make sure Nut Plate Thread is protected using paint screw,. 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5189559 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5192331
 240 - (QC14- Inspect Spray Paint)
 244 - (Wing Walk as per dwg QSI005 4.4 Batch 5185147)
 246 - (QC3- Inspect Part Finish)
 250 - (Assemble as per dwg) 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.
 260 - (QC5- Inspect part completeness to step on W/O) Inspect Nut Plate & Inserts
 270 - (Assemble as per dwg) 1-Install wearpads as per Dwg D3274. 2-Install ring as per Dwg D3274 3-Inspect for foreign objects as per QSI 024 4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.
 280 - (QC5- Inspect part completeness to step on W/O)
 290 - (Identify as per dwg & Stock Location: _____) Location : FG073
 295 - (Document Control) Photocopy bluefile & type labels per PPP D206-642- 541 CHG005
 300 - (QC21- Final Inspection - Work Order Release) 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 using DT10280 and deburr.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3274-041BENT	Skidtube Assembly 206	1 pcs (1 ea)	110-Skidtubes - 1	5189763
D3285-1	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5043738
D3282-041	Float Web (206L/407)	1 pcs (1 ea)	150-Skidtubes - 2 - B4B	5191855
D2649	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5156881
D3275-1	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5148269
ALS4-1032-130	Rivnut	78 Ea (78 ea)	250-Handfinish - 4-1-Assembly-B4B	5057267
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5099573
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	F11137886-1 017512
D3415-041	Nut Plate	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	F147134
AN3C4A	Bolt	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5192134
AN4C5A	Bolt	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5057496
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5160607
D3413-1	O-Ring	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	x 5207076
D3537-1	Wearpad	9 pcs (9 ea)	270-Handfinish - 4-2-Assembly-B4B	5201500
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5195634
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	F164008
D4956-15	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5200829
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201248
D4956-35	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201108
D4956-39	Wearplate Center Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201005
NAS1149C0332R	Washer	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5193136
NAS1149C0463R	Washer	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5104377

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D3274-041BENT	1	3	0
	D3285-1	1	13	0
150-Skidtubes - 2 - B4B	D3282-041	1	1	0
190-Skidtubes - 4 - B4B	D2649	12	128	0
	D3275-1	12	104	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	78	7,437	0
	CCR264SS3-3	2	159	0
	CR3212-4-03	2	84	0
	D3415-041	1	9	0
270-Handfinish - 4-2-Assembly-B4B	AN3C4A	80	858	0
	AN4C5A	1	55	0
	D2646	1	32	0
	D3413-1	1	17	0
	D3537-1	9	59	0
	D3537-3	1	18	0
	D3672-1	2	1,677	0
	D4956-15	1	4	0
	D4956-23	1	10	0
	D4956-35	1	8	0
	D4956-39	1	1	0
	NAS1149C0332R	80	2,866	0
	NAS1149C0463R	1	279	0

Part Specifications

Specifications could not be found.

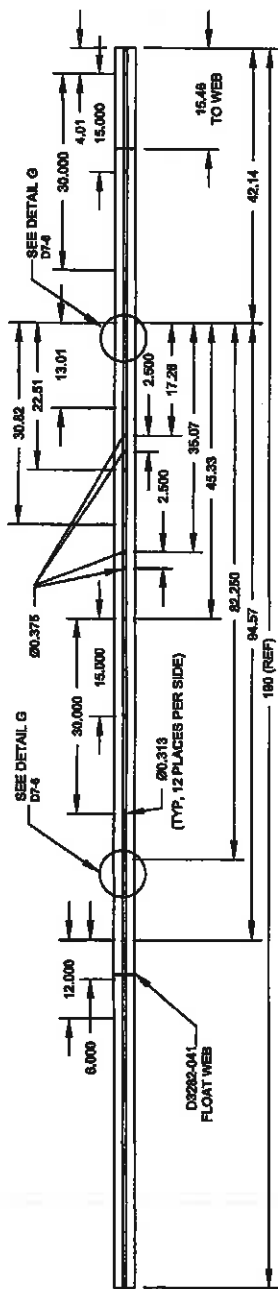
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D3274-043 DRILLING/ASSEMBLY DETAIL

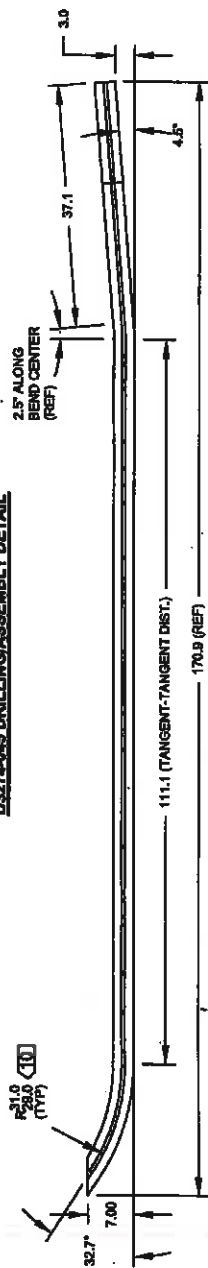
D3274-143 BEND/DRILLING DETAIL

D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

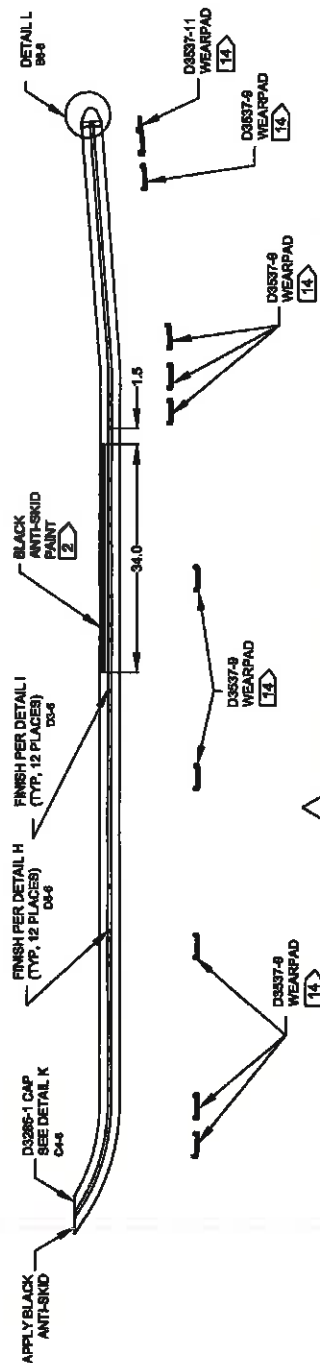
DESIGN	CP	DART AEROSPACE USA, INC EUGENE, OR REV. 3 OF 8 SHEET 3 OF 8 SCALE NTB
DRAWN	RF	
CHECKED	AK	
INFG. APPR.	JLM	
APPROVED	DS	
DE APPR.	AK	TITLE SKIDTUBE ASSEMBLY D3274 DRAWING NO.
DATE	16.04.25	COPYRIGHT © 2004 DART AEROSPACE USA, INC ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.



D3274-045 DRILLING/ASSEMBLY DETAIL



D3274-045 BEND/DRILLING DETAIL



G D3274-045 SKIDTUBE ASSEMBLY
(SEE DETAIL J FOR WEARSHOE INSTALLATION)

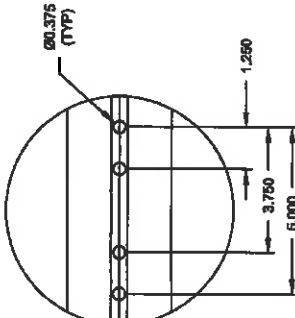
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DRAWN						
CHECKED						
INFO. APPR.						
APPROVED						
DE APPR.						
DATE						16.04.25

DART AEROSPACE USA, INC		EUGENE, OR		REV. G	
DRAWING NO.		D3274		SHEET 4 OF 6	
TITLE		SKIDTUBE ASSEMBLY		SCALE	
NTS					

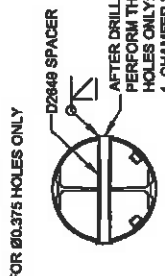
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DETAIL A: DRILL DETAIL
B2-2, B2-3, D3-3



DETAIL B
B2-2, B2-3

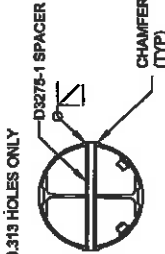


FOR Ø0.375 HOLES ONLY

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:

1. CHAMFER HOLE 0.030x45°
2. INSERT D2848 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE TO Ø0.313x0.75 DEEP

DETAIL C
B2-2, B2-3



FOR Ø0.313 HOLES ONLY

D3275-1 SPACER

CHAMFER 0.030x45° (TYP)

DETAIL D
A2-2, A2-3



ALST-1032-130 INSERT (1)

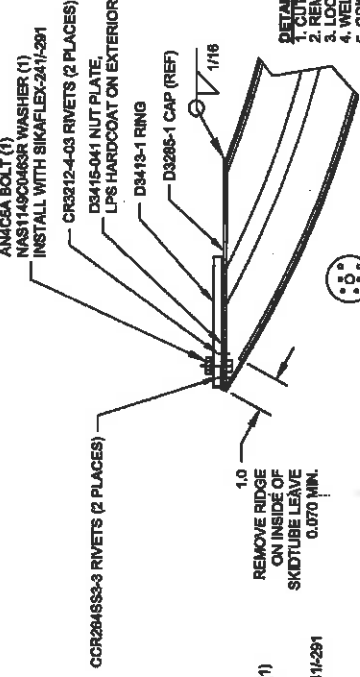
AN8C4A BOLT (1)

NAS1149C0332R WASHER (1)

(78 PLACES)

WEARSHOE/WEARPAD (REF) G

DETAIL E: END FINISHING DETAIL
B7-4, B7-3

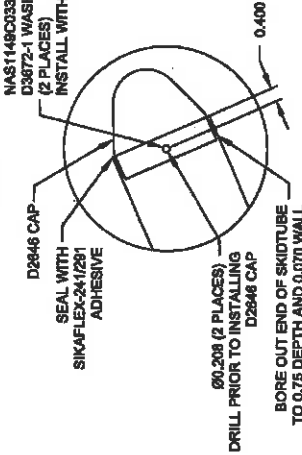


DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. GRIND FLUSH (IF NECESSARY)
4. WELD D3285-1 IN PLACE PER DRT Q81 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
7. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

DETAIL F
B2-2, B2-3



D2848 CAP

SEAL WITH SIKAFLEX-241/281 ADHESIVE

AN8C4A BOLT (1)

NAS1149C0332R WASHER (1)

D3872-1 WASHER (1)

INSTALL WITH SIKAFLEX-241/281

Ø0.208 (2 PLACES)

DRILL PRIOR TO INSTALLING D2848 CAP

BORE OUT END OF SKIDTUBE TO 0.75 DEPTH AND 0.070 WALL

DESIGN	CP	RF	REV. G
DRAWN	AK	JLM	D3274
CHECKED	AK	JLM	D3274
APPROVED	AK	JLM	D3274
DATE	16.04.25		
TITLE	SKIDTUBE ASSEMBLY		
SCALE	NTS		

RELEASED
R 2016-07-26

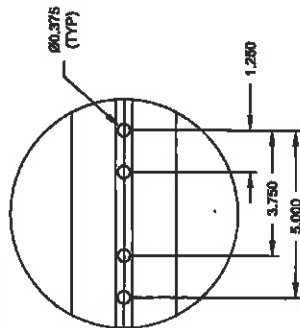
-041/-043 DETAILS

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DETAIL G: DRILL DETAIL
B-4, 10-4



DETAIL H
B-4

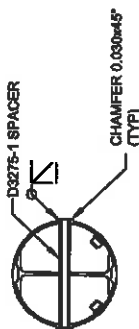
FOR 0.0375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.0375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2846 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO 0.0313x0.75 DEEP

DETAIL I
B-4

FOR 0.0313 HOLES ONLY



DETAIL J
A-4



ALST-1032-130 INSERT (1)
AN3024 BOLT (1)
NAS1148C0332R WASHER (1)
(40 PLACES)

DETAIL K: END FINISHING DETAIL
B7-4

MS27030C4-08 SCREW (1)
NAS1148C0463R WASHER (1)
INSTALL WITH SIKAFLEX-241-291
CR3212-4-03 RIVETS (2 PLACES)
D3415-041 NUT PLATE.
LPS HARDCOAT ON EXTERIOR
D3285-1 CAP (REF)

REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

DETAIL L
B-4

AN3024 BOLT (1)
NAS1148C0332R WASHER (1)
D3872-1 WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241-291

D2846 CAP
SEAL WITH
SIKAFLEX-241-291
ADHESIVE



DETAIL K NOTES

1. REMOVE RIDGE ON FWD SIDE
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART Q81 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASED
R 2016-07-26

-045 DETAILS

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐									
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)													
Description Work Order Deviation				Disposition															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY															
				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
				Other/Details: _____															
Completed By				Lead hand / Supervisor															
QC / QA Coordinator																			